



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PB67-43001-07
Job Sheet 173134



Part No: PB67-43001-07

Job Qty: 4 ea

Part Name: Fwd Blade Fold Assembly Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 4/16/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A 08-06-25 new issue DD verified by:ec IPP rev B 10.09.24 per revC dwg EC verified by:DD IPP REV:C 14.12.15 DWG REV.D DD VERF:JLM IPP REV:D 16.11.21 DWG REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		4/13/18	0.00	0.00	Start Up Large Fab-7		CPC
100	Large Fab	4 pcs		4/14/18	0.00	28.57	Large Fab 2		CPC
110	QC	4 pcs		4/14/18	0.00	0.00	QC9		2018.04.13
120	QC	4 pcs		4/14/18	0.00	0.00	QC5		2018.04.13
130	Powdercoat	4 pcs		4/16/18	0.00	1.29	Powdercoat5		2018.04.13
140	QC	4 pcs		4/16/18	0.00	0.00	QC3		CPC
150	Packaging	4 pcs		4/16/18	0.00	0.00	Packaging3-2		CPC
160	QC21-SA	4 Ea		4/16/18	0.00	0.00	QC21		DAS

Part Op 100 - 1- Assemble parts on jig DT8813 and weld as per dwg PB67-43001 *** Ensure no burn thru after welding in tube
Descriptions: -205 and -197 only where bushing -265 ***

130 - ***MASK ALL OPENING AND INDICATED AREAS PRIOR TO POWDERCOATING, SEE NOTE 9 SHEET 2-3****

FINISH TIME: 9:25 A.T. 3:20 FINISH 9:35

in 139014

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3440-15	Contoured Male Eye (Supersedes B67-43001-215)	4 Ea (1 ea)	90-Start up Operation	160143
D3440-5	Contoured Detent Clip Base (Supersedes B67-43001-217)	4 Ea (1 ea)	90-Start up Operation	160145
D3440-7	Detent Clip Base (Supersedes B67-43001-221)	4 Ea (1 ea)	90-Start up Operation	160144
PB67-43001-197W	Outer Tube Weldment	4 Ea (1 ea)	90-Start up Operation	160950
PB67-43001-201	Square Tube	4 Ea (1 ea)	90-Start up Operation	160816
PB67-43001-203W	Square Tube Weldment	4 Ea (1 ea)	90-Start up Operation	160942
PB67-43001-205W	Outer Tube Weldment	4 Ea (1 ea)	90-Start up Operation	160945
PB67-43001-207W	Square Tube Weldment	4 Ea (1 ea)	90-Start up Operation	5053407
PB67-43001-209	Square Tube	4 Ea (1 ea)	90-Start up Operation	160824
PB67-43001-211	Square Tube	24 Ea (6 ea)	90-Start up Operation	5053269
PB67-43001-219	Angled Male Eye	4 Ea (1 ea)	90-Start up Operation	1601068
PB67-43001-47	Base Assembly	4 Ea (1 ea)	90-Start up Operation	5058227

002367

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3440-15	4	5	0
	D3440-5	4	5	0
	D3440-7	4	5	0
	PB67-43001-197W	4	5	0
	PB67-43001-201	4	15	0
	PB67-43001-203W	4	9	0
	PB67-43001-205W	4	5	0
	PB67-43001-207W	4	0	0
	PB67-43001-209	4	10	0
	PB67-43001-211	24	6	0
	PB67-43001-219	4	5	0
	PB67-43001-47	4	0	0
Part Specifications				
Specifications could not be found.				

Plex 2/27/18 9:33 AM Dart.Gagnon.Michelle



Container No: S059527



Part: PB67-43001-07

Job No: 173134

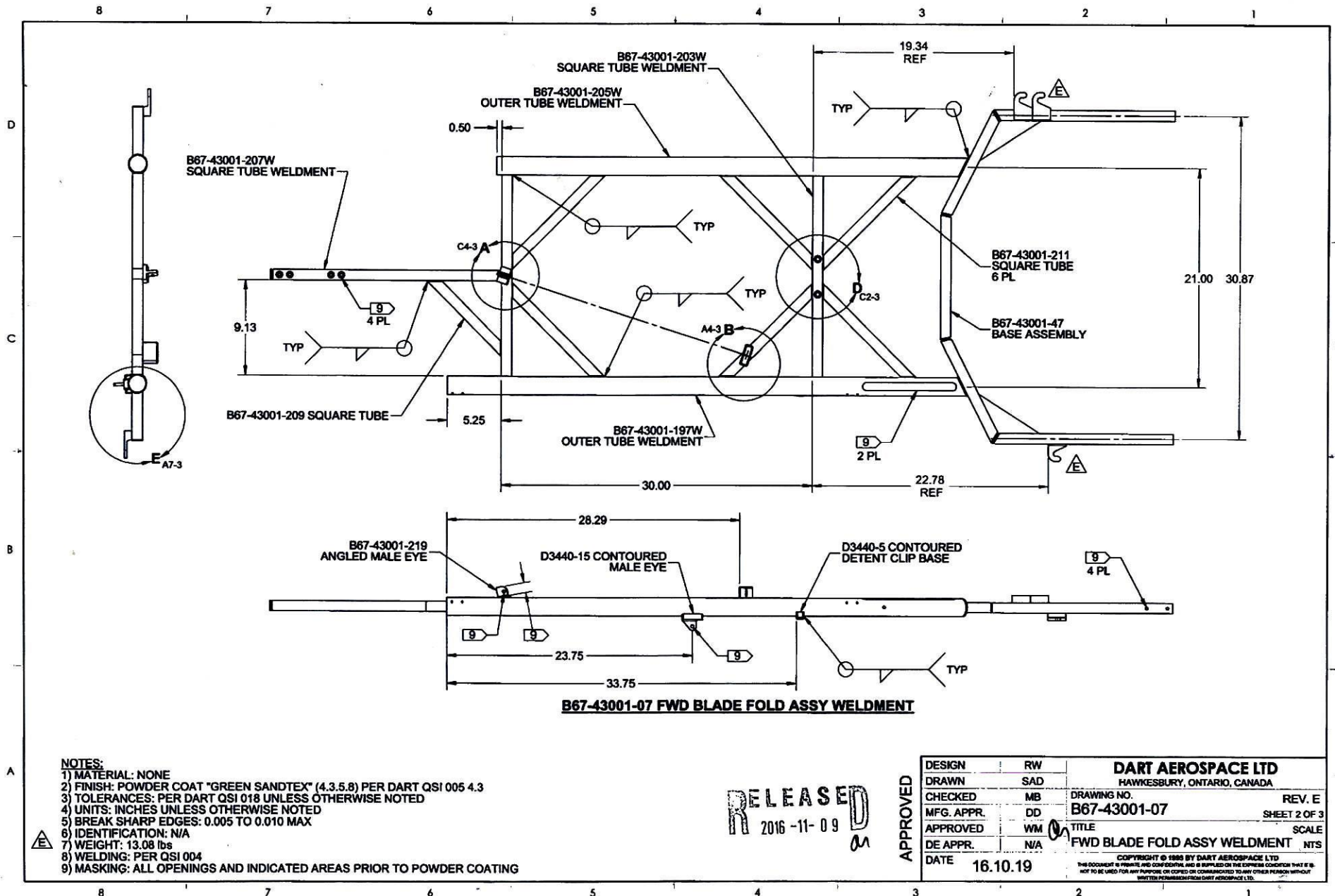
Serial No/Batch: S059527

Revision:

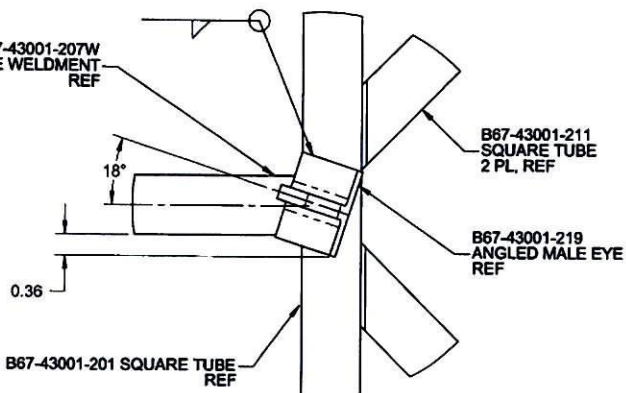
Inspector:

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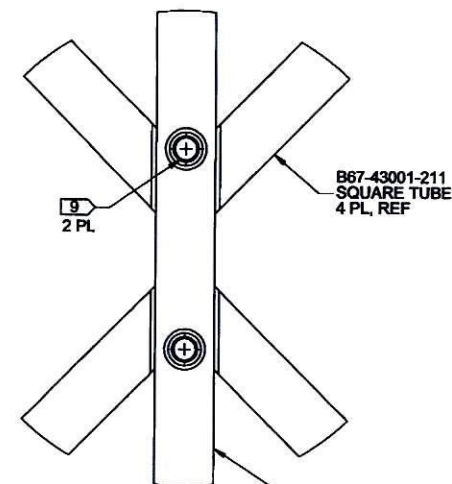
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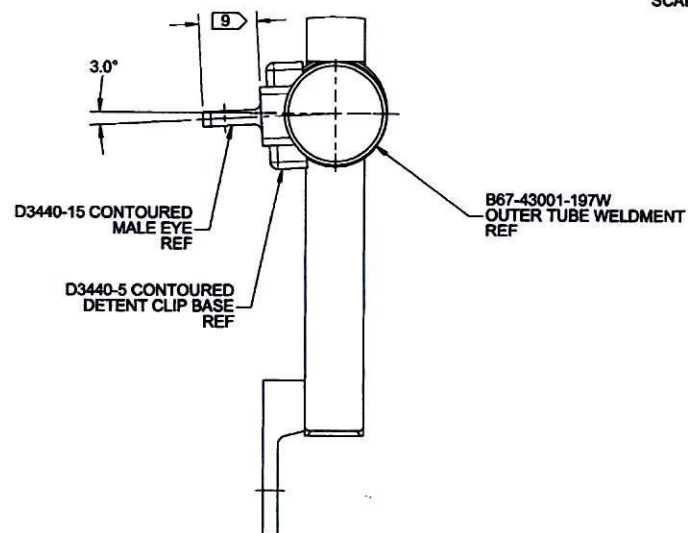
B67-43001-207W
SQUARE TUBE WELDMENT
REF



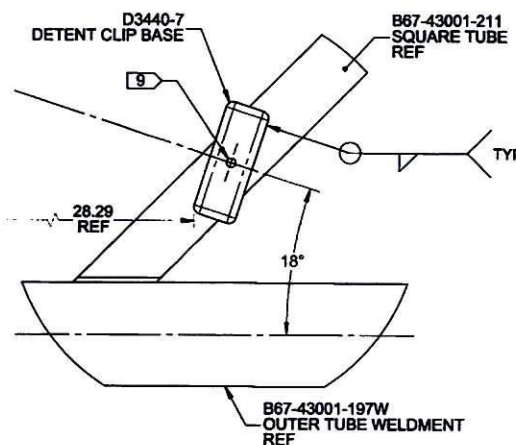
DETAIL A
SCALE 4X C6-2



DETAIL D
SCALE 4X C3-2



DETAIL B
SCALE 4X B8-2

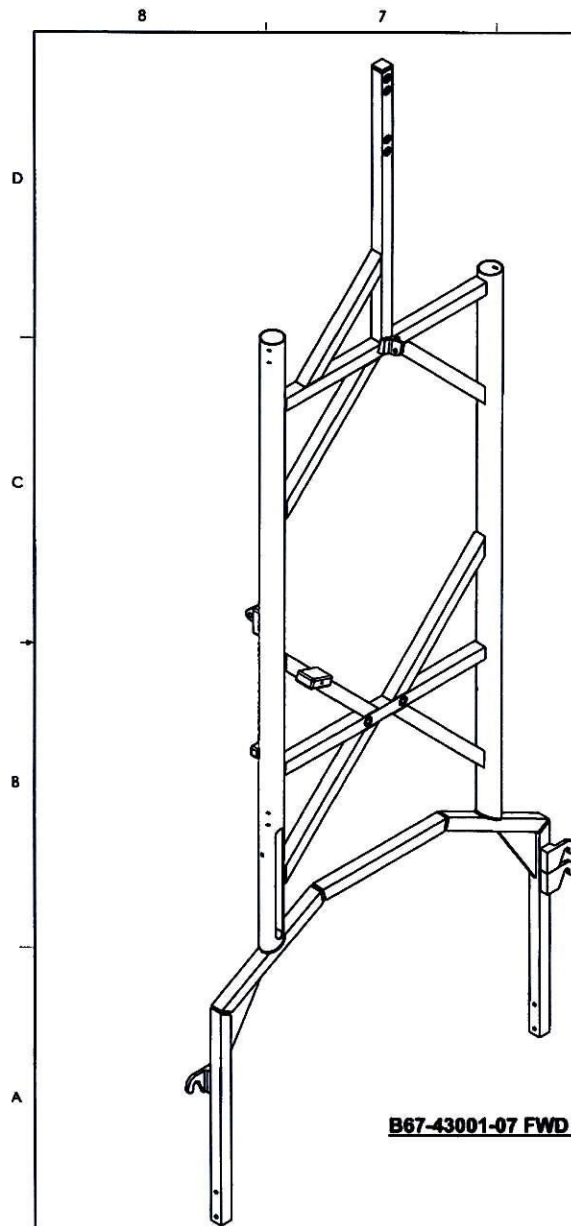


DETAIL C
SCALE 4X C4-2

RELEASED
2016-11-09

APPROVED

DESIGN	RW	DART AEROSPACE LTD	
DRAWN	SAD	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DD	B67-43001-07	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
DATE	16.10.19	COPYRIGHT © 1985 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



B67-43001-07 FWD BLADE FOLD ASSY WELDMENT

RELEASED
2016-11-09
2016-11-09
01

ITEM	QTY -07	P/N	DESCRIPTION
1	X	B67-43001-07	FWD BLADE FOLD ASSY WELDMENT
2	1	B67-43001-47	BASE ASSEMBLY
3	1	B67-43001-197W	OUTER TUBE WELDMENT
4	1	B67-43001-201	SQUARE TUBE
5	1	B67-43001-203W	SQUARE TUBE WELDMENT
6	1	B67-43001-205W	OUTER TUBE WELDMENT
12	1	B67-43001-207W	SQUARE TUBE WELDMENT
8	1	B67-43001-209	SQUARE TUBE
9	6	B67-43001-211	SQUARE TUBE
10	1	B67-43001-219	ANGLED MALE EYE
11	1	D3440-5	CONTOURED DETENT CLIP BASE
12	1	D3440-7	DETENT CLIP BASE
13	1	D3440-15	CONTOURED MALE EYE

E	REMOVED MASKING IN HOOK AREA ON B67-43001-07 (ZNB2-2) (ZND2-2) VERIFIED MATERIAL SPECIFICATIONS: WEIGHT AFFECTED (ZNA2-2), REASON PARTS-437	SAD	16.10.19
D	REVISE BOM AND ANNOTATIONS TO INCLUDE -197W/-203W/-205W & -207W WELDMENTS. DELETE DETAIL C REASON: TO FACILITATE MANUFACTURING	DB	14.07.23
C	REDRAWN PREMIER AVIATION DRAWING IAW DART OSI 016 AND OSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 5 OF PREMIER AVIATION DRAWING # B67-43001. REASON: SEE PAR #09-011	MB	10.05.04
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SAD		
CHECKED	MB	DRAWING NO.	REV. E
MFG. APPR.	DO	B67-43001-07	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	N/A	FWD BLADE FOLD ASSY WELDMENT	NTS
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